

Date: Thursday, 4/5/2007 11:59:13 AM
 User: Kim Johnston

Process Sheet

Split 120028

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LID PRO ARM ASSEMBLY (SHORT)
 Job Number : 31694-2
 Estimate Number : 10258
 P.O. Number : *NA* Part Number : D2332041
 This Issue : 4/5/2007 S.O. No. : *NA* Drawing Number : D2332 REV C1
 First Rev. : NC Project Number : N/A
 First Issue : *NA* Type : SMALL /MED FAB Drawing Revision : C1
 Previous Run : 31105 Material : *NA*
 Written By : Due Date : 5/5/2007 Qty: 20 Um: Each
 Checked & Approved By : *Am 04.05*
 Comment : Est: B 02-08.12 Re-format; Incorporated D2332-13/-11/-71-5 K
 J/R/F

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304TR1000W049 304 RD Tube 1.0" x .049W



Comment: Qty.: 0.4368 f(s)/Unit Total: 8.7360 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless)

Batch

(M103240)

2.0 M304R250 1/4" 304 SS Roundbar



Comment: Qty.: 0.1092 f(s)/Unit Total: 2.1840 f(s)

Material: Ø0.250" 304SS Rod

Batch *PA 103129 M104129*

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



20

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin

3-Debur

(PTC)
07/06/25

4.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 1.2080 f(s)/Unit Total: 24.1600 f(s)

304 RD Tube .500 x .035W

Batch *103902**M1046401*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 31694

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012
(Note: Make (2) D2332-11 Prop Arms per assembly.)

Batch: M103487

FF 07-04-26 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly) -
- Ensure to remove foreign objects.

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

A/R SS Rod Batch: M102756

RD 07-02-21 07-06-21

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Assemble as per Dwg D2332

SAN 07/06/28

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

M101291

104

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 31694

Part Number: D2332041

Job Number:



Seq. # Machine Or Operation: Description :

11.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	AN960JD416L	Washer	M104214

12.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21042L4	Nut (or -4)	M102552

SAD

07/06/28

(20)

13.0 QC5 INSPECT WORK TO CURRENT STEP



7-6-28 ①

Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A for assembly 'rush'

7-6-28 ①

15.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

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7-6-28

Job Completion



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